

Work Order ID 101716-2 *split*

May-13-13 1:12:37 PM

101716

0850-591-121

B101716

REVE

Page 1

Item ID: D350-591-121

Revision ID:

Item Name: Heli-Access-Step, LH

Start Date: 5/13/13 Start Qty: 4.00

Required Date: 5/24/13 Req'd Qty: 4.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: *MCS*

QC:

Date: 13-05-14 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D2351 Rev E

100

100

DC

Document Control

DOCUMENT CONTROL

Memo *M.C.*

Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

0.00

0.00

110

110

Large Fab

Large Fab

Large Fab

Memo

1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

3-Deburr

0.00

0.00

7 # 6 *13.04.27*



Work Order ID 101716

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Page 2

Item ID: D350-591-121

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step. LH

Start Date: 5/13/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

CNC Bender I

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

0.00

Bend as per Dwg D2351-041 using CNC Bender I and Folio FT011. Use Bend Program D2351-041.

DP 13-6-27

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

7 φ

68-6
61
SV0

13.07.02

140

140

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Bevel Fwd and Aft end for welding

2-Weld Aft End Bracket per OSI 004 & Dwg D2351 using Welding Jig DT8033

A/RAluminum Rod 125127

3-Do not Grind Flush

7 φ

M

13.07.02

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Page 3

Item ID: D350-591-121

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step, L11

Stop *NS2*

Start Date: 5/13/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

① B-07-02

DAV
09

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

① B-07-02

DAV
09

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

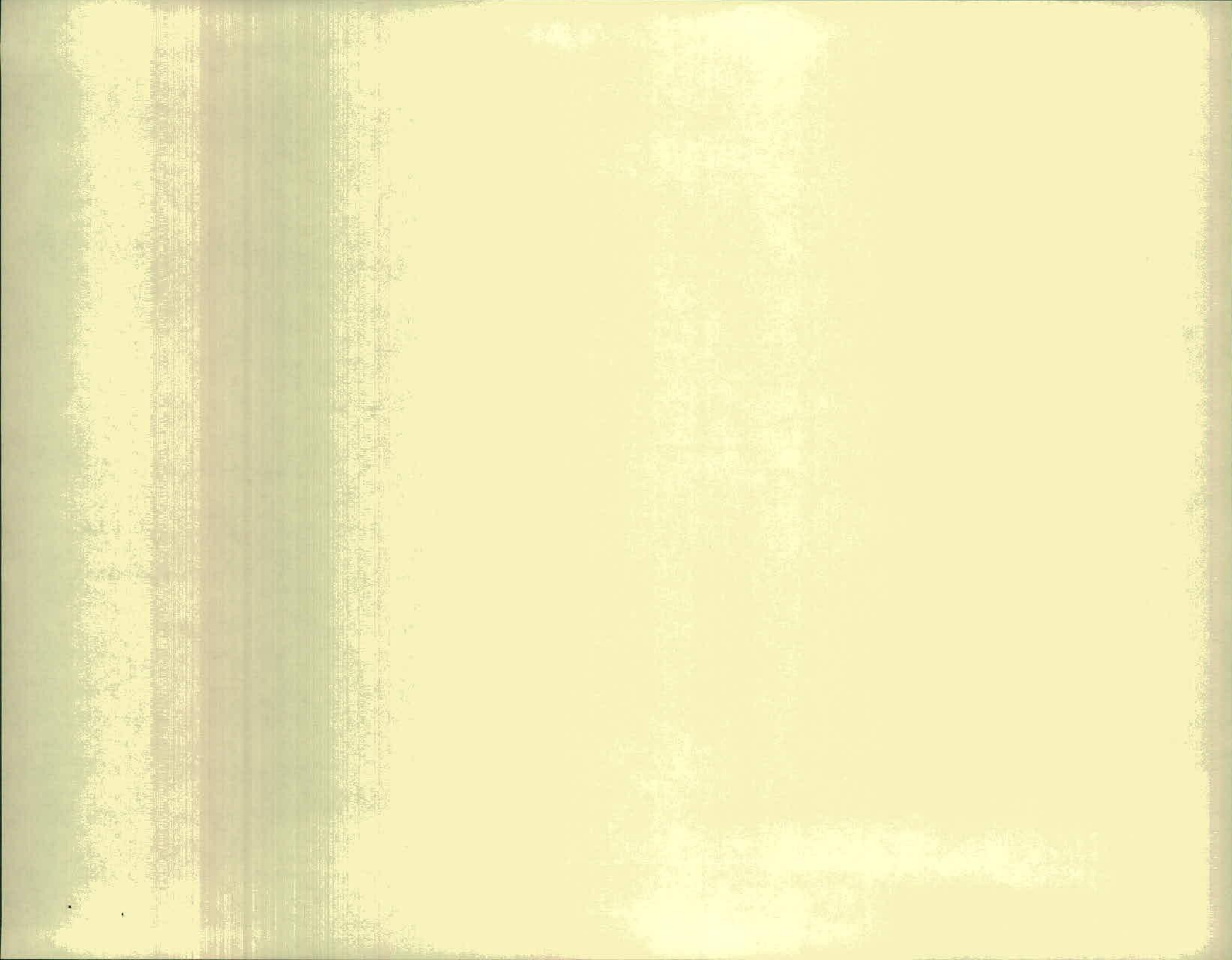
HandFinish

Memo

0.00

Hand Finishing

7 16-13-22



Work Order ID 101716

May-13-13 1:42:37 PM

101716

Page 4

Item ID: D350-591-121

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step, LH

Stop *NS2*

Start Date: 5/13/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC7-Inspect Chemical Conversion Coat

0.00

180

QC

Memo

0.00

Quality Control

① 13-03-03

DAS
09
2-8

190

Large Fab

0.00

190

Large Fab

Memo

0.00

Large Fab

1-Rivet Leg Assembly as per Dwg D2351

2-Weld Fwd End Plate per QSI004 & Dwg D2351

A/RAluminum Rod H2501

3-Grind end cap flush per dwg D2351

① 13-07-03

PD

220

QC10- Inspect visual per QSI004- ground welds

0.00

220

QC

Memo

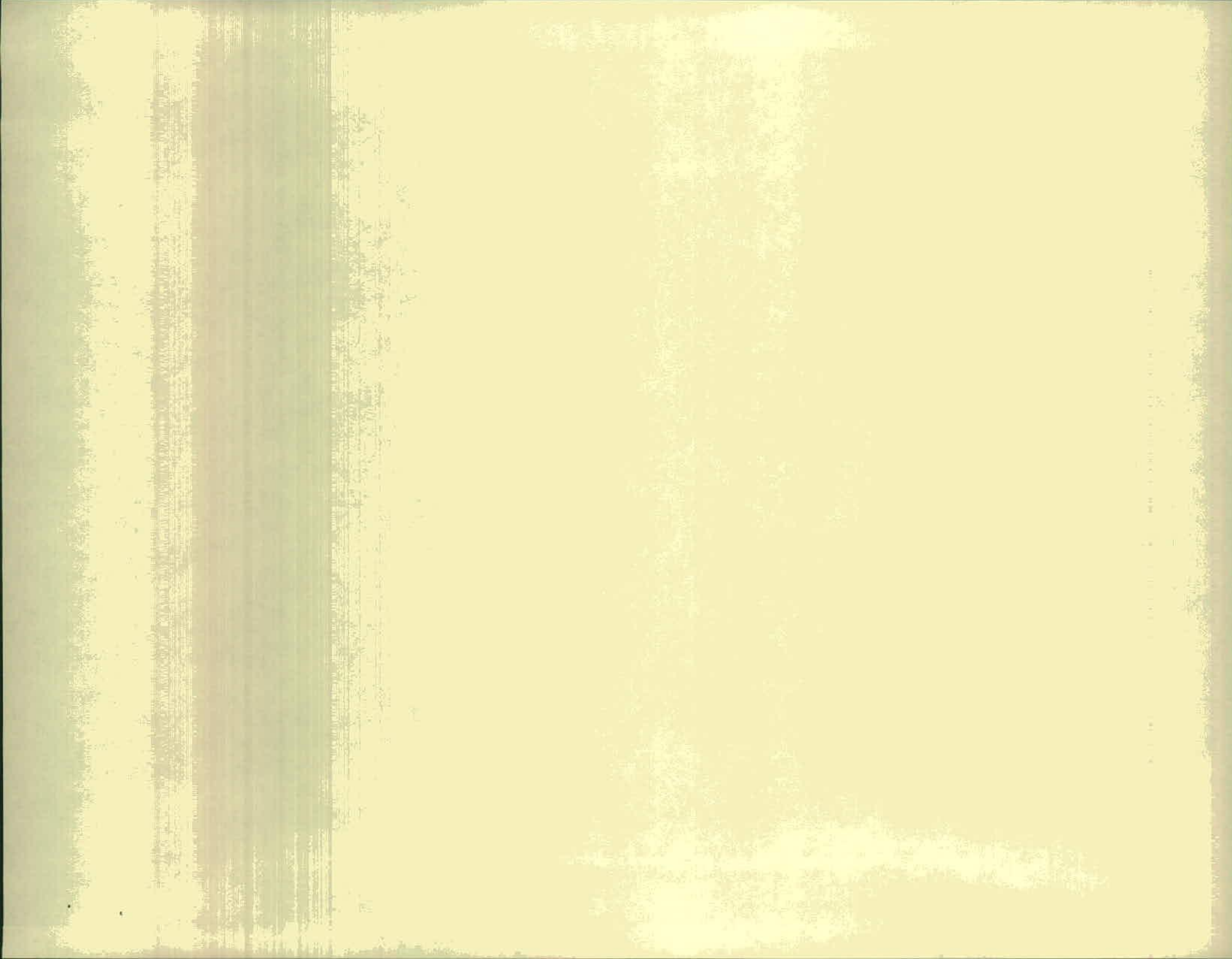
0.00

Quality Control

DAS
16
2-5

13/7/04

x7



Work Order ID 101716

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Page 5

Item ID: D350-591-121

Revision ID:

Item Name: Heli-Access-Step, LH

Start Date: 5/13/13 Start Qty: 4.00

Required Date: 5/24/13 Req'd Qty: 4.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC5- Inspect part completeness to step on W/O

0.00

DAS
10
35

13/07/04

230

QC

Quality Control

Memo

0.00

r7
LH

240

Chemical Conversion Coat per QSI005 4.1

0.00

240

HandFinish

Hand Finishing

Memo

0.00

7xLH m-f 13/07/04

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

250

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9-45
3200F
10-15

7xLH m-f 13/07/04
LH

m/25620

Work Order ID 101716

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101716

Page 6

Item ID: D350-591-121

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step, LH

Stop *NS2*

Start Date: 5/13/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

260

Wing Walk as per dwg QS1005 4.4 Batch 126051 0.00

260

HandFinish

Memo

0.00

Hand Finishing

7 φ PK 13-7-A.

270

QC3- Inspect Part Finish

0.00

270

QC

Memo

0.00

Quality Control

7h1 d Ill 13/07/06

280

Pick Kit

0.00

280

Packaging

Memo

0.00

Packaging

7x M.D. 13-07-04
QR

Work Order ID 101716

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Page 7

Item ID: D350-591-121

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, LH

Start Date: 5/13/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

290

QC4- 100% Inspect kits for completeness

0.00

290

QC

Memo

0.00

Quality Control

13-7-9

300

Packaging

0.00

300

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591-121

Location: _____

PPP Rev: _____

5x 13-7-9

310

QC21- Final Inspection - Work Order Release

0.00

310

QC

Memo

0.00

Quality Control

13/7/10

130710



Picklist Print

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Page 1

Work Order ID: 101716
 Parent Item: D350-591-121
 Parent Item Name: Heli-Access-Step, LH

Start Date: 5/13/13
 Start Qty: 4.00

Required Date: 5/24/13
 Required Qty: 4.00

Comments: IPP Rev:E02.10.21Re-format: Incorporated D2351-041 IPPKJ/RF
 IPP rev. F 06.02.23 added grinding EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116 Step Extrusion		Manufactured	No			110	Each	69.2105	0.5	2.1052632		11.13.07.02	

Location	Loc Qty	Loc Code
WA	-0.0000368	
WA003	69.2104894	
60307	2	
80803	18.2104894	
89954	49	

D2850-1
End Bracket

Manufactured No

140 Each 10.0000

1 4

11.13.07.02

Location	Loc Qty	Loc Code
WA003	10	
92457	10	

D2582
Step Leg Assembly

Manufactured No

190 Each 4.0000

1 4

11.13.07.03 PD

Location	Loc Qty	Loc Code
WA003	4	
89203	1	
97854	3	

MS20600-AD4W3
Cherry Rivets

Purchased No

190 Each 1,123.0000

16 64

11.13.07.03 PD

Location	Loc Qty	Loc Code
ST311	990	
122151	4	
122452	4	
123525	294	
124231	688	
WA003	133	
107939	133	

112



Picklist Print

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Page 2

Work Order ID: 101716
 Parent Item: D350-591-121
 Parent Item Name: Heli-Access-Step, L11

Start Date: 5/13/13 Required Date: 5/24/13
 Start Qty: 4.00 Required Qty: 4.00

D2673-34 Manufactured No 210 Each 38.0000 1
 End Plate

13-07-03 20

Location	Loc Qty	Loc Code
WA003	38	
97990	38	

B105317-57

AN4-16A Purchased No 290 Each 563.0000 2
 Bolt

14 M.H. 13-07-04

Location	Loc Qty	Loc Code
FG	5	
121541	5	
ST357	58	
124215	58	
ST514	200	
125427	200	
ST515	200	
125396	200	
ST517	100	
125388	100	

14x

* D2856-400 7.20
 Abrasion Strip

Manufactured No 290 f 264.5839 0.6 2.4

M.H.

Location	Loc Qty	Loc Code
ST408	151.05	
99378	151.05	
ST410	38.5	
95159	38.5	
ST415	75.0339	
63735	0.6696	
68076	0.3149	
71164	8.46	
81875	6.398	
86905	0.9569	
89352	24.6745	
90764	33.56	

B101773

cut 1 x 7.20"
 x(7) 17 Wm
 S13M/65

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 101716

Parent Item: D350-591-121

Start Date: 5/13/13

Required Date: 5/24/13

Parent Item Name: Heli-Access-Step, L11

Start Qty: 4.00

Required Qty: 4.00

S
+1
AN960JD416
Washer
D2230-1
Lug

NAS1149D0463J
Purchased No
Manufactured No

290 Each 0.0000
290 Each 185.0000

6
126221
X42
7/11. 13-07-58
X7
7/11
88

S
+1

Location	Loc Qty	Loc Code
FG	4	
84136	4	
ST469	181	
89783	16	
95217	120	
96247	21	
97814	24	

6K1834

S
+1
AN3-37A
Bolt

Purchased No

290 Each 436.0000

2
X14
7/11
88

Location	Loc Qty	Loc Code
FG	10	
119086	10	
ST513	426	
123355	426	

14x

S
+1
MS21042L3
Nut

Purchased No

290 Each 3,977.0000

2
X4
7/11
88

Location	Loc Qty	Loc Code
FP001	3	
122141	3	
GA	18	
122452	18	
ST314	268	
117885	32	
119017	55	
119075	138	
123265	43	
ST506	3688	
123900	954	
124291	2734	

126036

May-13-13 1:12:36 PM

Shop Packet Print

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Picklist Print

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Page 4

Work Order ID: 101716
Parent Item: D350-591-121
Parent Item Name: Heli-Access-Step, LH

Start Date: 5/13/13
Start Qty: 4.00

Required Date: 5/24/13
Required Qty: 4.00

AN4-13A
Bolt Purchased No

290 Each 825.0000 3

21 17.10.13-C7-04

Location	Loc Qty	Loc Code
FG	20	
122808	20	
Return2012	8	
122416	8	
ST513	774	
125388	774	
ST514	23	
122993	13	
123900	10	

125388

MS21042L4
Nut Purchased No

290 Each 3,411.0000 3

21 17.10.13

Location	Loc Qty	Loc Code
FP001	50	
122452	38	
8182	12	
st507	3000	
125535	3000	
ST518	361	
124231	361	

125708

D2230-3
Lug Manufactured No

290 Each 412.0000 1

7 17.10.13

Location	Loc Qty	Loc Code
FG	4	
89045	4	
ST469	408	
89782	19	
90514	1	
94957	4	
96117	7	
97815	373	
97903	4	

101495

May-13-13 1:12:36 PM

Shop Packet Print

Page 4



Picklist Print

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Page 5

Work Order ID: 101716
Parent Item: D350-591-121
Parent Item Name: Heli-Access-Step, LH

Start Date: 5/13/13

Required Date: 5/24/13

Start Qty: 4.00

Required Qty: 4.00

*

~~D2732-030~~
Rubber Cushion

Manufactured No

290 Each 95.0000

~~138~~

M.D. 13-07-04

cut (4) at 3.00"
x 7 = 14 x 3.00"
weaver
5/3/13/05

Location

Loc Qty

Loc Code

FG	86
83560	86
ST415	9
92772	2
98629	7

694725 (10x)

88

S
71

AN960JD10
Washer

NAS1149D0363J Purchased

No

290 Each 0.0000

4

~~28~~

124392

M.D.

88

May-13-13 1:12:36 PM

Shop Packet Print

Page 5



DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

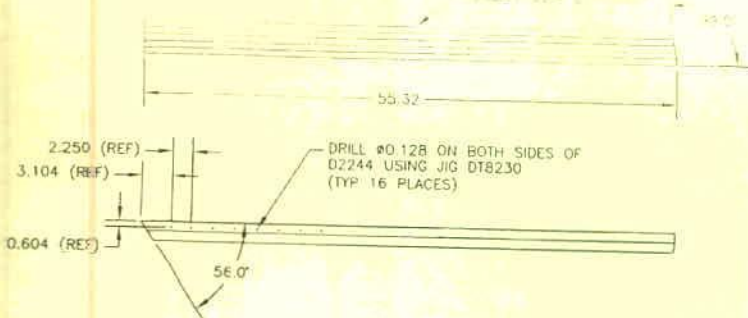
*cut per drawing

101716 MJS
13-05-14**RELEASED**
05.11.28 #PH
ECN 1105**UNDER REVIEW**07.11.29 #
PER NCR # 263

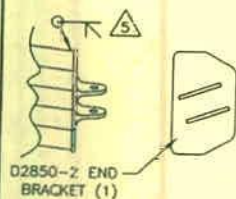
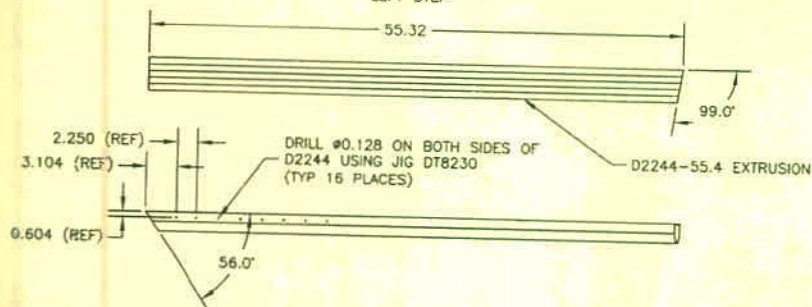
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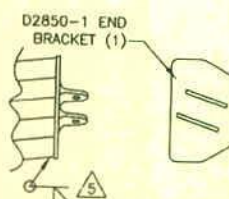




D2351-1 CUTTING/DRILLING DETAIL
LEFT STEP

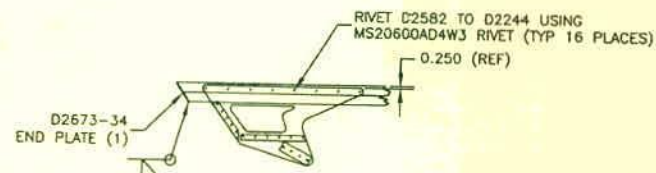


DETAIL A
SCALE: 1:4

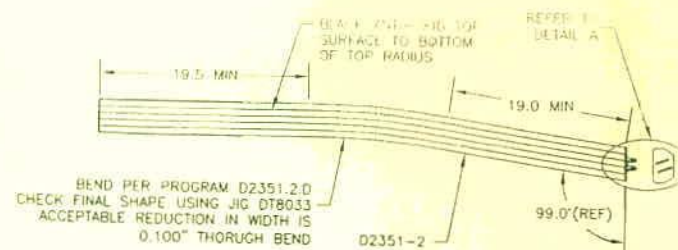


DETAIL B
SCALE: 1:4

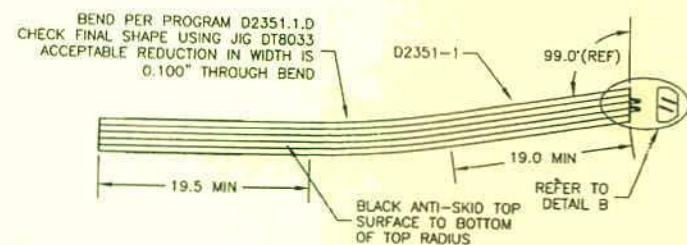
D2582 STEP LEG ASSEMBLY (1)



D2673-34
END PLATE (1)



D2351-041 BENDING/ASSEMBLY DETAIL
LEFT STEP



RELEASED
05.11.28

UNDER REVIEW

GENERAL NOTES

- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CHAMFER D2244 EXTRUSION 0.075"x45" BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, GBR
KE	PH	DART	
CHECKED	APPROVED	DART	
DATE	DRAWING NO.	DART	
05.11.14	D2351	DART	
	TITLE	DART	
	HIGH FLOAT STEP ASSEMBLY	DART	

REV. E

SHEET 2 OF 2

SCALE

1:12

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

Ref. 5136/05

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	Heli-Access-Step™, Short Step – High Skid, LH
	X				D350-591-122	Heli-Access-Step™, Short Step – High Skid, RH
		X			D350-591-123	Heli-Access-Step™, Short Step – Low Skid, LH
			X		D350-591-124	Heli-Access-Step™, Short Step – Low Skid, RH
				X	D350-591-133	Heli-Access-Step™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT

The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.






Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9459	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OPTIONAL CLAMP MODIFICATIONS	NTS
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